

Date: Thursday, 11/22/2007 9:59:52 AM
User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE EXTRUSION
Job Number : 35960	
Estimate Number : 10050	
P.O. Number : <i>N/A</i>	Part Number : D6207
This Issue : 11/22/2007 S.O. No. : <i>N/A</i>	Drawing Number : D6207 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 27538	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 12/5/2007
Checked & Approved By : <i>[Signature]</i>	Qty : 12 Um : Each
Comment : Est. A: 02.03.15 New Issue NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *3116*

07/11/22

(12)

- a) Description: Angle extrusion 25 ft long 1.000" x 1.000" x 0.125"
- b) Material: 6061-T6/T6511 (QQ-A-200/8)
- c) Minimum ultimate tensile strenght = 38 ksi
- d) Minimum yield tensile strenght = 35 ksi

2.0	D6207P	Angle Extrusion 1x1x.125
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Comment: Qty.: 1.0000 f(s)/Unit Total : 12.0000 f(s)
Angle Extrusion 1x1x.125

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
Ensure material certification is attached

07/14/28 (12)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6207
Check hardness with Webster tester

07/14/28 x 12 feet

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

J.F. 07/11/28 x 12 feet

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 8/11/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(D)

Comment: FINAL INSPECTION/W/O RELEASE

DOX/11-30

Job Completion



LL OF-11-30

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

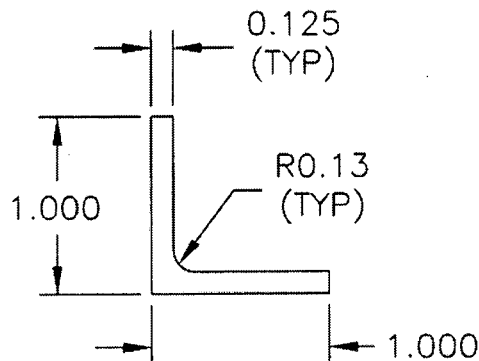
NOTE: Date & initial all entries



DESIGN [Signature]	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D6207	REV. A SHEET 1 OF 1
DATE 02.03.13		TITLE ANGLE EXTRUSION	SCALE 1:1
A	02.03.13	NEW ISSUE	

RELEASED
02.03.13

SPECIFICATION CONTROL DRAWING



D6207-XXX ANGLE EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6207-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM ANGLE
1.000" x 1.000" x 0.125"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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CUSTOMER ORDER NO.: N20381
CUSTOMER PART NO: V840052



MILL TEST REPORT

CUSTOMER

REPORT: 56656

SAMPLE (S) OF ALUMINUM

DIE NO.	S-2228
DESCRIPTION	1"X1"X1/8" ANGLE
AL. ALLOY & TEMPER	6061/T6
EXTRUDEX ORDER NO.	97755-4-A.11
SPECIFICATION	ASTM B221
SILICON %	0.58
IRON %	0.26
COPPER %	0.21
MANGANESE %	0.08
MAGNESIUM %	0.83
CHROMIUM %	0.06
ZINC %	0.03
TITANIUM %	0.01
ALUMINUM %	REMAINDER
ALLOY TYPE %	6061
ALLOY CAST NO.	2592
YIELD STRENGTH (IN ksi)	40.7
TENSILE STRENGTH (IN ksi)	45.3
ELONGATION % IN 2"	12.1
HARDNESS (ROCKWELL 'F')	87.1
	87.5
	87.1

commande 874346
client 24532-5
7446128

N. RAMPERTAB
(LAB. TECH.)
OCT-31-07

DATE:

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